

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002004**Date Inspected:** 18-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M, 114M, Orthotropic Box Girders (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item Description	WBS	Dwg No.	Status
1 Tower Skin Plate	NA	NA	Welding

New Tower Shop Bay 1: ZPMC performed submerged arc welding (SAW), tower skin plate splice weld, joining plate P661 (S) to P124 (S) plate. The welder operator is identified as Ms. Xu Yan, welder stamp 052917, utilizing welding procedure WPS-B-T-2221-B-U3c-S-1; weld joint SSD1-SA216 E/G- 10A. Caltrans QA measured current welding parameters at approximately 630 amps, 32.0 volts and 610mm/min (millimeters per minute) travel speed. Caltrans QA verified preheat and interpass temperatures during the welding activities. The preheat temperature prior to the start of welding measures more than 110 degrees Celsius but less than 230 degrees Celsius during maximum interpass temperature verification. Caltrans QA observed ZPMC QC inspector, Mr. An Qing Xiang and ABF Inspector, Mr. Dai Qing Wen monitoring welding activities at the work station. The following digital picture illustrates welding in progress.

WELDING INSPECTION REPORT

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|---|-------------------|----|----|---------------------------|
| 2 | Tower Skin Plates | NA | NA | Flame Cutting and Milling |
|---|-------------------|----|----|---------------------------|
- New Tower Shop Bay 1: Caltrans QA observed ZPMC shop worker flame cutting tower skin plate components at the burn table, flame cutting of bevels at one location and the beveling of plate bevels at the horizontal milling machine.

Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
